Dart Aerospace Ltd.

Date: Friday, 9/1/2006 12:10:33 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: OH-58 STEP ASSY RH *UNDER REVIEW**
Job Number	: 28394		
Estimate Number	: 12439		
P.O. Number	: N/A	**Part Number**	: D058677012
This Issue	: 9/1/2006 **S.O. No.** : N/A	**Drawing Number**	: D2943 ~~UNDER REVIEW~~ 06.09.01
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: UNDER R
Previous Run	: 28050	**Material**	: N/A
Written By	:	**Due Date**	: 9/20/2006 **Qty:** 3 **Um:** Each
Checked & Approved By	: 06.09.01		
Comment	: Est Rev:B 01.04.11 Combined with D2943-041 EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
	Comment: Photocopy bluefile & type labels per PPPD058-677-012 CHG 001		06-09-06 KJ.
2.0	D2622120C	Extrusion	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Extrusion D2622-120C Batch: 327077		06.09.06 3
3.0	D2734	206 Step Endplate	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) D2734 206 Step Endplate Batch: B 27281		06.09.06 3
4.0	D2725	206 Step Lug	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) D2725 206 Step Lug Batch: B 20783		06.09.06 3
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
	Comment: LARGE FABRICATION RESOURCE 1		
	1-Cut D2943-1 from D2622 extrusion as per Dwg D2943		06-09-06 3
	2-Deburr and bevel ends for welding		06.09.12 3
	3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT ~~8482~~ 8483		06.09.13 3

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** OH-58 STEP ASSY RH *UNDER REVIEW**

Job Number: 28394 **Part Number:** D058677012

Job Number:

Seq. #:	Machine Or Operation:	Description :
	A/R AL ROD Batch: M100660	
	4-Grind end cap welds flush as per dwg D2943	P.E. 06.09.13 3
6.0	QC5/9	WELD INSPECTION
	Comment: WELD INSPECTION	06/09/20 (3)
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	FC 06 09 21 (3)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	P.E. 06.09.21 3
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482 A/R AL ROD Batch: M15689 2-Grind end cap welds flush as per dwg D2943	P.E. 06.09.21 3 FF 06.09.21 (1) P.E. 06.09.22 (2)
10.0	QC5/9	WELD INSPECTION
	Comment: WELD INSPECTION	06/09/22 (3)
11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Touch up Chemical Conversion Coat as per QSI 005 4.1	a.m 06-09-23 (3)
12.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	a.m 06-09-24 (3)

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Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** OH-58 STEP ASSY RH *UNDER REVIEW**

Job Number: 28394 **Part Number:** D058677012

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Wing Walk as per Dwg D2943 and QSI 005 4.4
Batch: M101667 a.m 06-09-25

Seq. #:	Machine Or Operation:	Description :
14.0	QC3/5	INSPECT WORK/WING WALK

Comment: INSPECT WORK/WING WALK

Seq. #:	Machine Or Operation:	Description :
15.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Seq. #:	Machine Or Operation:	Description :
16.0	D27311	Mounting Lug

Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Mounting Lug
Batch: B15282 ✓

Seq. #:	Machine Or Operation:	Description :
17.0	D27313	Mounting Lug

Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) ✓
Mounting Lug B20614

Seq. #:	Machine Or Operation:	Description :
18.0	D27315	Mounting Lug

Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Mounting Lug
Batch: B22591 ✓

Seq. #:	Machine Or Operation:	Description :
19.0	D27317	Mounting Lug

Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Mounting Lug
Batch: B22592 ✓

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes $\boxed{\text{No}}$ DQA: [illegible] Date: 06/09/28

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

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Job Number: 28394

Part Number: D058677012

Job Number:

Seq. #:	Machine Or Operation:	Description :
20.0	AN411A	Bolt
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s) Bolt Batch: M100743 3mcp M17771 1mcp ✓	
21.0	AN412A	Bolt
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s) ✓ Bolt M101350	
22.0	MS21042L4	Nut
	Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s) ✓ Nut Batch: M19099 06/9/27 (3)	
23.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS 06/09/27 (3)	
24.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP Do58-677-012 Location: PPP Rev: B 06/9/28 (3)	
25.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21 (3) 06/09/28	

Job Completion 06-09-28

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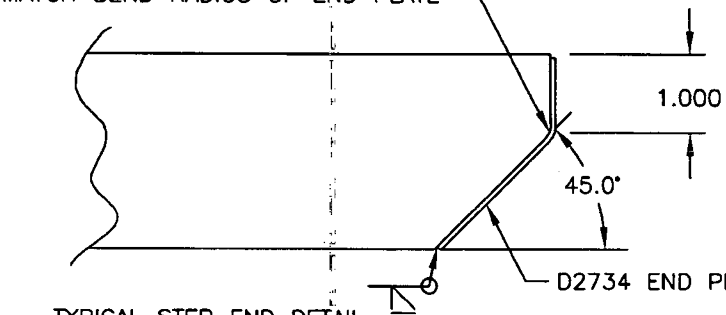
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

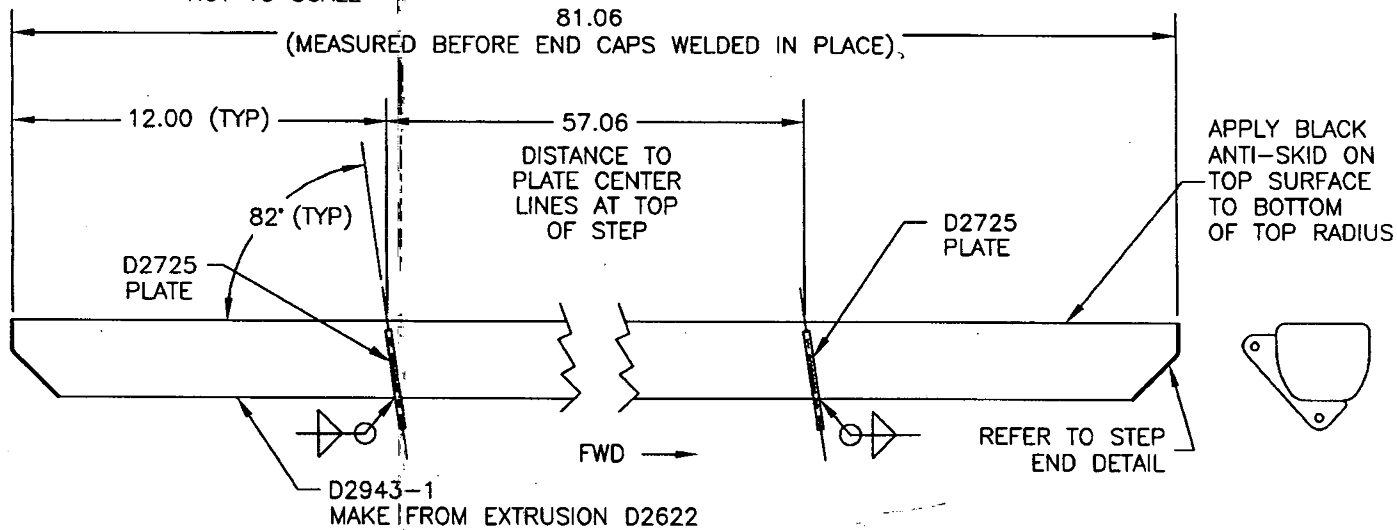
QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2943-041 LH STEP ASSEMBLY (SHOWN)
D2943-042 RH STEP ASSEMBLY (OPPOSITE)

D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2943-041	LH STEP ASSEMBLY
	X	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

*cut per drawing

D2943-041/-042 OH-58 STEP ASSEMBLY NOTES

1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 28394

UNDER REVIEW 06.03.29 RE-DESIGN SIMILAR TO D2U6-633

RELEASED 05.11.28

REV	DATE	DESCRIPTION
A	99.11.19	NEW ISSUE
B	05.11.14	UPDATE FINISHING NOTE

DART

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DESIGN	DRAWN BY	DRAWING NO.	REV. B
RF		D2943	SHEET 1 OF 1
CHECKED	APPROVED	TITLE	SCALE
DATE 05.11.14		OH-58 STEP ASSEMBLY	NTS